

Date: Tuesday, 1/8/2008 1:19:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LOCK PLATE
Job Number : 36662	
Estimate Number : 10332	
P.O. Number :	Part Number : D2534
This Issue : 1/8/2008 S.O. No. :	Drawing Number : D2534 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 35367	Material :
Written By : <u>JA 08.01.08</u>	Due Date : 1/21/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JA 08.01.08</u>	
Comment : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now on Waterjet 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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2.2



Comment: Qty.: 0.0448 sf(s)/Unit Total : 1.7934 sf(s)
 304/316 .125 Sheet
 (M304S11GA)
 Batch: 104934 HB 8-1-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2734
 Dwg Rev: D
 Prog Rev: D

HB 8-1-11

2-Deburr if necessary

(47)

JA 08/01/17

(47)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-1-11



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JA 08/01/17 (47) counts

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT Dural

08/01/18 (47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/8/2008 1:19:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOCK PLATE

Job Number: 36662

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.07.21

Job Completion



2008/1/21

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36662
Description: Lock Plate		Part Number:	D2534
Inspection Dwg: D2534 Rev: D		Page 1 of 1	

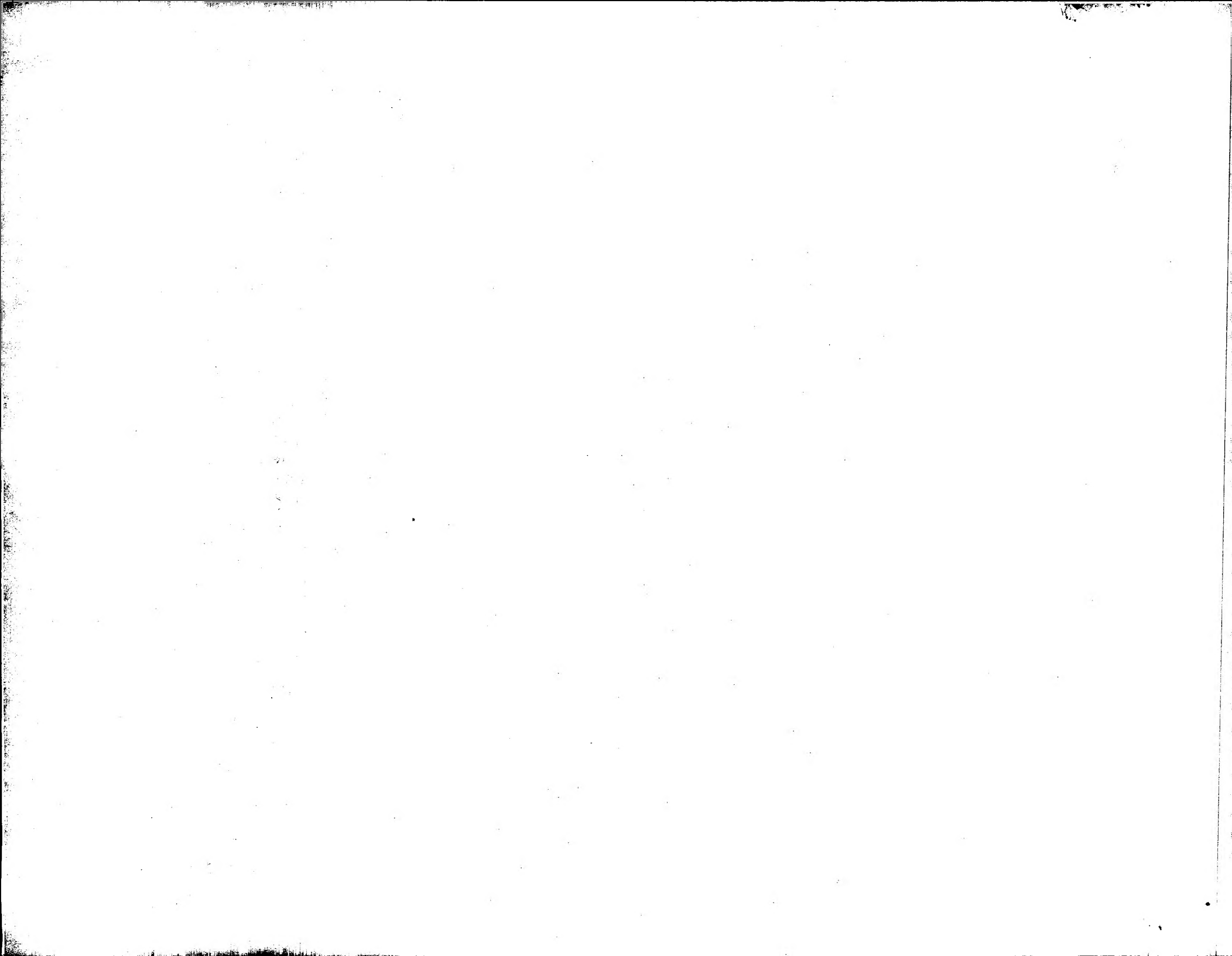
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.447	+0.006/-0.001	.448	X			
R0.500	+/-0.010	.500	X			
R0.173	+/-0.010	.173	X			
R0.096	+/-0.010	.096	X			
R0.125	+/-0.010	.125	X			
R0.120	+/-0.010	.120	X			
R0.200	+/-0.010	R.200	X			
0.125	+/-0.010	.122	X			

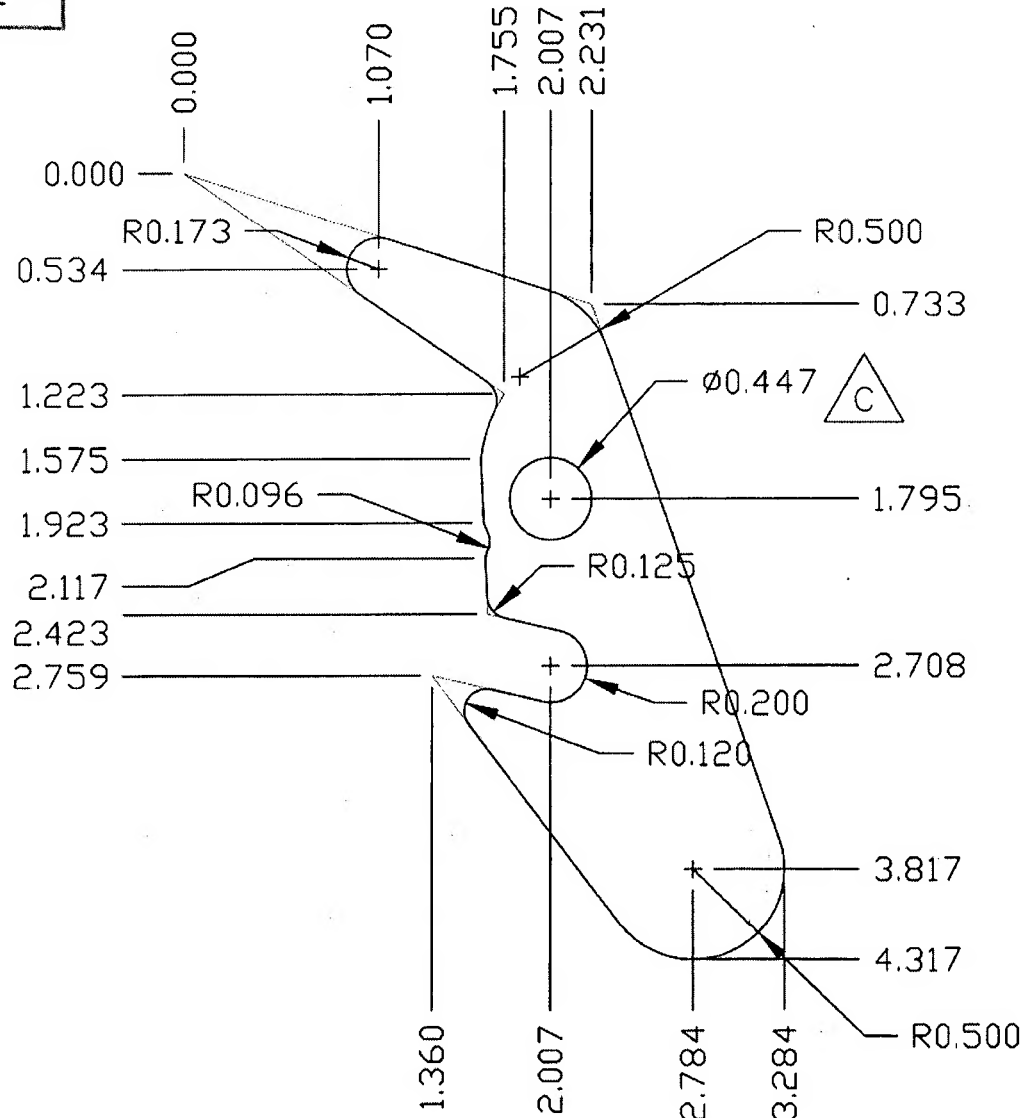
Measured by:	DB	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	8-1-11	Date:	08/01/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM [Signature]	[Signature]



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2534	REV. D SHEET 1 OF 1
DATE 04.12.14	TITLE LOCK PLATE		SCALE 1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **36662**